

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029180**Date Inspected:** 26-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** USA Hoist, Crest Hill, IL

<b>CWI Name:</b>	Robert Zimny		
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>
<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>
<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>
<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>
<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>
<b>Component:</b>	SAS Tower Elevator	

**Bridge No:** 34-0006**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Fritz Belford was at the USA Hoist shop in Crest Hill, Illinois between the times noted above in order to monitor Quality Control functions and the in process work being performed by USA Hoist personnel. The following items were observed:

**Matt Wasigi (A):**

Welder Wasigi was observed removing the temporary mounting bolts of the Door Mesh to the Door Assembly and replacing them with the M8 x 25MM LG, FHCS bolts for the Door Mesh and Door Assemblies 1, 4 & 5. Welder Wasigi was also observed finishing the welding of door hinges to number 3 Door Stop Assembly using 1.1mm E71T-1C Familiarc DW-50 wire electrode. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 37 CFH. The welding parameters measured were 26 volts and 195 amperes and were in compliance with the Welding Procedure Specification (WPS) FCAW3210.

**Jose Dominguez (C):**

Welder Dominguez was observed machine cutting 6" x 6" x .375" tubular steel (Heat#0168580) for the elevator tower. At the end of the shift approximately 21 tubes had been cut using the Marvel band saw to cut the tubes to the specified lengths. Cutting will continue on the following shift.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

documents.



**Jose Dominguez (C):**  
Welders Dominguez and Ulloa stacking the 6" x 6" x .375" tubular steel (Heat#0168580) for the elevator tower after cutting.



**Matt Wasigi (A):**  
Welder Wasigi replacing the temporary mounting bolts of the mesh to the door frame with the M8 x 25MM LG, FHCS bolts.

## Summary of Conversations:

Conversations this day as required for scope of work.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Belford,Fritz
----------------------	---------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Foerder,Mike
---------------------	--------------

QA Reviewer
-------------